

Date: Tuesday, 24/02/2009 8:21:56 AM
 User: Jean-Luc Menard

Process Sheet

| | | | |
|-----------------------|--|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : OUTSIDE WASHER |
| Job Number | : 46044 | | |
| Estimate Number | : 11154 | | |
| P.O. Number | : | Part Number | : D32335 |
| This Issue | : 24/02/2009 S.O. No. : | Drawing Number | : D3233 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 24/02/2009 Type : MACHINED PARTS | Drawing Revision | : B |
| Previous Run | : 45325 | Material | : |
| Written By | : <u>Jan 09.02.24</u> | Due Date | : 03/03/2009 Qty: 10 Um: Each |
| Checked & Approved By | : | | |
| Comment | : Est. A 05.03.14 New issue KJ/JLM Est Rev:B Now on Doosan Lathe 08-04-01 JLM Verified by:EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------------|--------------------------|
| 1.0 | M1020TR1875W250 | ROUND TUBE 1.875 x .250w |
|-----|-----------------|--------------------------|



Comment: Qty.: 0.1860 f(s)/Unit Total : 1.8596 f(s)

1020-1025 Round Tube

Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020

SRA or AMS 5075 or AMS 5077

(M1020TR1.875W.250)

Identify for D3233-5

Batch: M110345

24 09/02/27

| | | |
|-----|--------------|--------------|
| 2.0 | DOOSAN LATHE | DOOSAN LATHE |
|-----|--------------|--------------|



Comment: Doosan Lathe

1- Turn as per Folio FA736 Rev: 1/A & Dwg D3233 Rev: 13

2-Deburr per dwg D3233

24 09/02/27

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

24 09/02/27

(10)

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

24 09/02/27

(10)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTSIDE WASHER

Job Number: 46044

Part Number: D32335

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Carl L

JS 09/03/02 K16

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/02 HJ

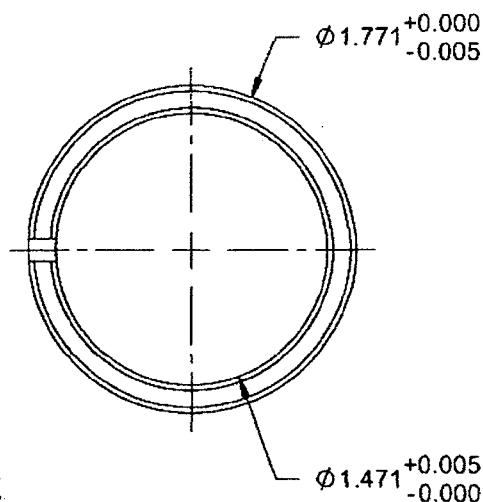
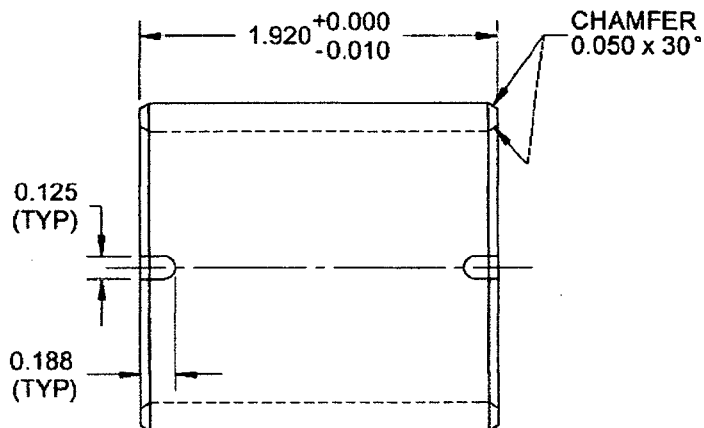
Job Completion



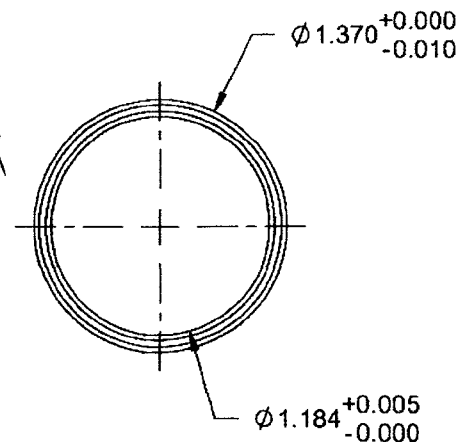
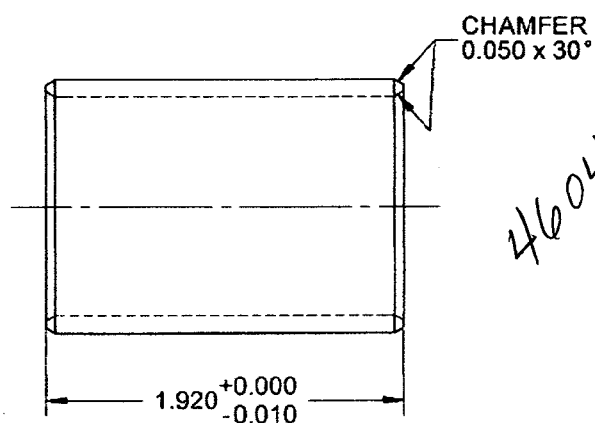
U 09.03.02



| | | | |
|-------------------------|--------------------------------|--|------------------------|
| DESIGN 13 | DRAWN BY 13 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED 13 | APPROVED 13 | DRAWING NO. D3233 | REV. B SHEET 3 OF 3 |
| DATE 05.03.08 | TITLE WHEEL ASSEMBLY | | SCALE 1:1 |



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5086 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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